

Tuesday, 6/19/2007 2:03:45 PM  
Kim Johnston

## Process Sheet

26

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT X-TUBE EXT HEIGHT GEAR
Job Number	: 32942		
Estimate Number	: 10421		
P.O. Number	: N/A	Part Number	: D205596103
This Issue	: 6/19/2007 S.O. No. : N/A	Drawing Number	: D205-596-103 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: A
Previous Run	: 32356	Material	: N/A
Written By	:	Due Date	: 6/29/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>Kim Johnston</u>		
Comment	: Est Rev:G 05.06.10 Acid etch moved to Step 11 KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy D205-594 bluefile &amp; type labels per PPP D205-596-103CHG001

KS 07.06.20 (1)

2.0	D2890	Aft Crosstube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2890 Aft Crosstube B33026

EL 7-8-16

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Mark 37.30" for cutting from tangential line in the straight section from D2890 as per Dwg wall template. EL 7-8-16

4.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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Comment: DIMENSIONAL CHECK OF X-TUBES

EL 07/08/16

5.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut as per Dwg D205-596-103 EL 7-8-17

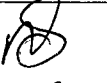


2-Deburr &amp; Inspect for surface damage. Polish cut surface. Scribe part # and batch # on one end of tube.

10 7-8-20

(PTO) →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 07/08/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/08/16	# 5.0	tube was slightly overbent at the height of 37.3"	 again	mark line and cut at 37.4" as per attached E. mail from David <del>Shepherd</del> Shepherd	EL 7-8-16	 07/08/16	 again	EL 07/08/16

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT X-TUBE EXT HEIGHT GEAR

Job Number: 32942

Part Number: D205596103

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

En 07/08/20

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

TOUCH UP Chemical Conversion Coat as per QSI 005 4.1

Jb 7-8-20

(PTO)

8.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside with Immron per QSI 005 4.2

25 07-08-25  
ml 07 08 23 (1)

9.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Jb 08-24 @

10.0

D2856600

Abrasion Strip



Comment: Qty.: 1.7640 f(s)/Unit Total : 1.7640 f(s)

Pick:

Qty Part number

Description

Batch

2 D2856-600(10.090")

Abrasion Strip

26650

ml 07 08 24

11.0

D29401

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

Description

Batch

2 D2940-1

Support

32169

ml 07 08 24

12.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number

Description

Batch

4 MS21920-28

Clamp

105385

ml 07 08 24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-08-21	7.1	QCS for cu + Leight + inspection	<i>[Signature]</i>	07-08-21	1	<i>[Signature]</i>	<i>[Signature]</i>
		Add QCS, perm. change. <i>[Signature]</i>				07-08-21	07-08-21

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 6/19/2007 2:03:45 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT X-TUBE EXT HEIGHT GEAR

Job Number: 32942

Part Number: D205596103

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Install abrasion strips per QSI 035 position using DT8582. Install supports and clamps per Dwg D205-596-103. Torque clamps to 80-100 in lb.

7 M 1060827  
070824 (PTE)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/27 (L)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-596-103

Location: \_\_\_\_\_

NEVER PC 7/8/28 (1)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AD 07/08/28

Job Completion


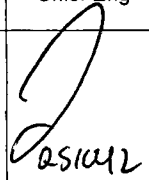
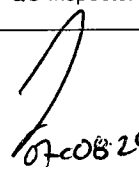


CD 07/08/28

# Dart Aerospace Ltd

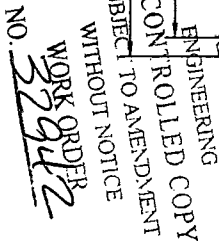
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/08/28  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
070824	13.0	Tube scratched from the table stands, when employee repositioned the tube on the back supports. RC: Fresh paint, and a heavy tube, sliding on the stand.		one side only. Sand paper smooth, and re-prime, and paint per QSI 005	ET 07-08-25	Er 07/08/27		

NOTE: Date & initial all entries

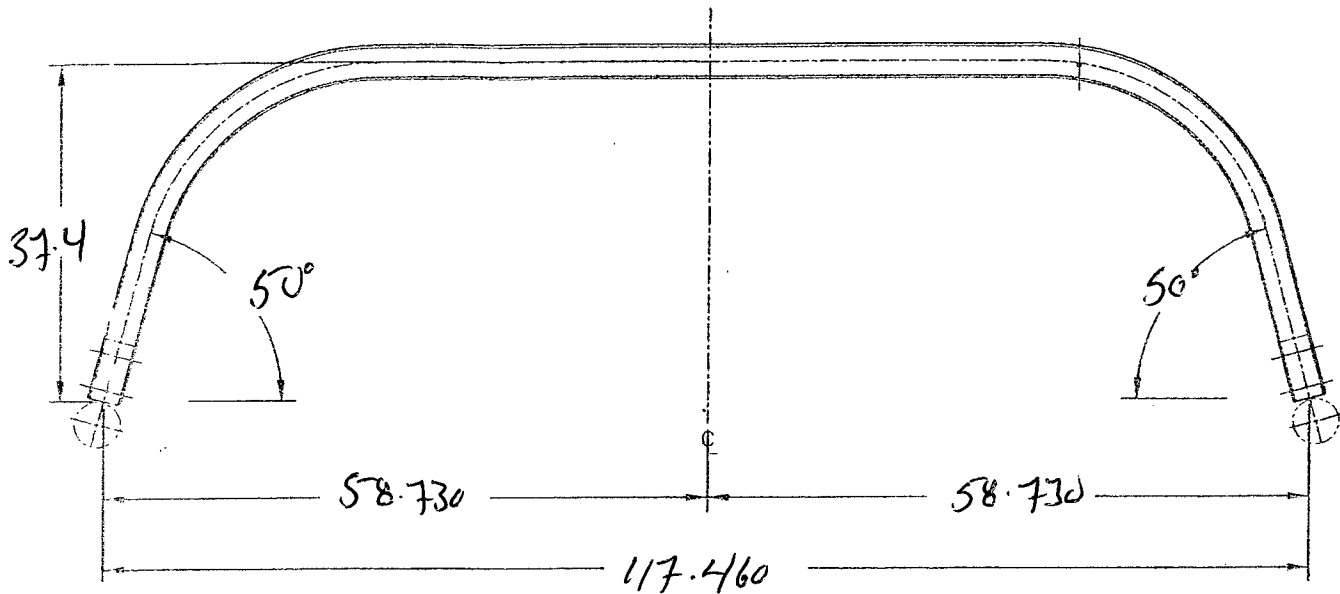
02.06.04



A	02.05.27	NEW ISSUE	
DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	<b>DART</b>	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D205-596-103	REV. SHEET 1 OF 1
DATE 02.05.27	TITLE XTUBE ASS'Y (HI-HI AFT)		SCALE 1:1

DART AEROSPACE LTD		Work Order:	32942
Description: Crosstube High-High Aft		Part Number:	D205-596-103
Inspection Dwg: D205-596-103 Rev: A		Page 1 of 1	

Required Dimension	Min	Max
Height	37.2	37.4
1/2 Span	58.7	58.9
Angle	49	52
Total Span	117.4	117.8



Comments
see attached e-mail from D.S for approval to cut at 37.4

QC15 Inspection	EP
Date	07/08/16

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	[Signature]



## Jason Murdoch

**From:** David Shepherd [dshepherd@dartaero.com]  
**Sent:** Thursday, August 16, 2007 12:33 PM  
**To:** 'Jason Murdoch'  
**Cc:** 'L Lacelle'; 'Jean-Luc Menard'  
**Subject:** FW: w/o 32942 D205-596-103  
**Attachments:** crosstube dims 2.jpg; crosstube dims 1.jpg

D205-596-103 B32942 is acceptable.  
Cut to 37.4 height.

David

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**From:** Jason Murdoch [mailto:jmurdoch@dartaero.com]  
**Sent:** Thursday, August 16, 2007 9:20 AM  
**To:** davids@dartaero.com; David Shepherd  
**Subject:** w/o 32942 D205-596-103

Morning David

I (Eric) have another D205-596-103 cross tube that is slightly over bent. It is even on both sides but as you can see from the dim sheets @37.3 it is under tol but @37.4 it is within tol.

I think that if I mark a line at the height of 37.4 it will be fine. I'm sorry to bother you about this but I just want your opinion about it.

Thanks  
Eric Downing

jmurdoch@dartaero.com  
Q.C. COORDINATOR

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**From:** Brigitte Golden [mailto:bgolden@dartaero.com]  
**Sent:** Thursday, August 16, 2007 10:02 AM  
**To:** 'Jason Murdoch'  
**Subject:** dims again

Hi Eric,

New scans with darker print. Let me know if these are ok, I did them highest res I could.

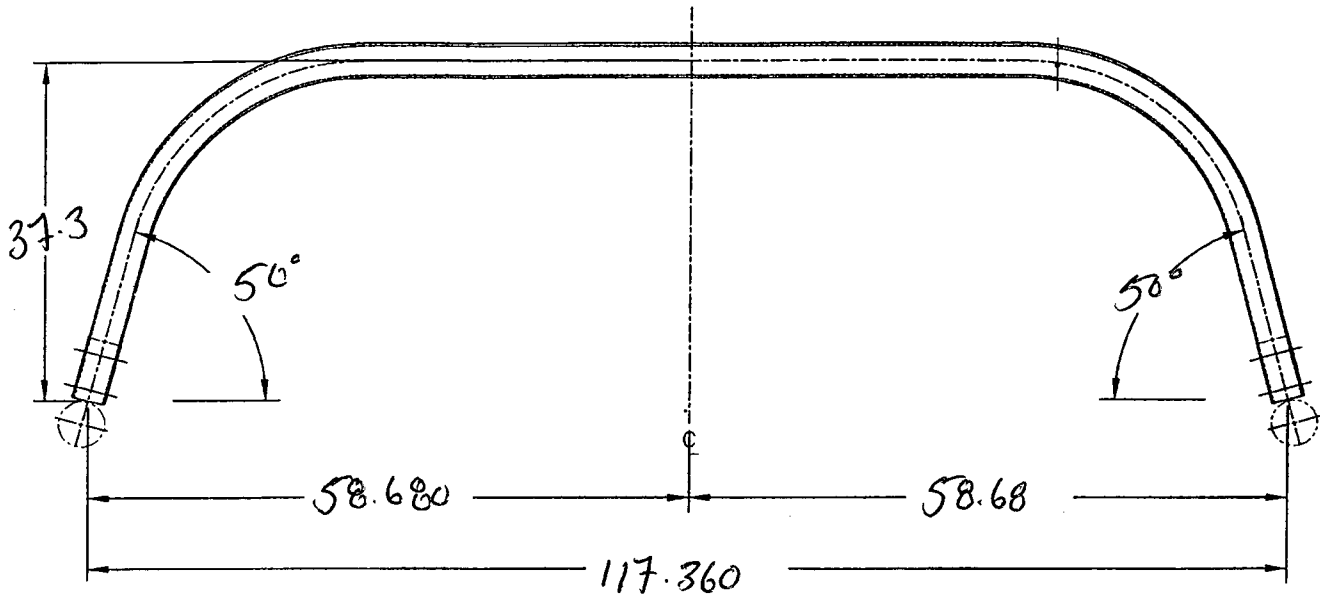
Brigitte Golden  
Order Processing  
Dart Aerospace Ltd.  
bgolden@dartaero.com

No virus found in this incoming message.  
Checked by AVG Free Edition.  
Version: 7.5.476 / Virus Database: 269.11.19/953 - Release Date: 8/14/2007 5:19 PM

8/16/2007

DART AEROSPACE LTD		Work Order:	32942
Description: Crosstube High-High Aft		Part Number:	D205-596-103
Inspection Dwg: D205-596-103 Rev: A		Page 1 of 1	

Required Dimension	Min	Max
Height	37.2	37.4
1/2 Span	58.7	58.9
Angle	49	52
Total Span	117.4	117.8



Comments
cut line as per email from David Shepherd.

QC15 Inspection	En <del>W</del>
Date	07/09/16

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	<i>[Signature]</i>